

Date: Tuesday, 23/12/2008 3:30:49 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD		
Job Number	: 44322					
Estimate Number	: 10313					
P.O. Number	:			Part Number	: D26483	
This Issue	: 23/12/2008		S.O. No. :	Drawing Number	: D2648 REV D	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: D	
Previous Run	: 44294			Material	:	
Written By	:			Due Date	: 20/01/2009	
Checked & Approved By	: <u>MF 08-12-24</u>			Qty:	20 Um: Each	
Comment	: Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF Est Rev:F Now on Waterjet 06-08-14 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010S16GA	1010/1025 sheet 16GA	
		Comment: Qty.: 0.0788 sf(s)/Unit Total : 1.5750 sf(s) 1010/1025/A21/6aA SHEET (M1010S16GA) Batch: <u>105704</u> <u>HB 9-1-6</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2648 *****CUT WITH FILE D2648-1***** Dwg Rev: <u>D</u> Prog Rev: <u>D</u>	
		2-Deburr if necessary <u>HB 9-1-6</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>HB 9-1-6</u>	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		<u>S 09/01/06</u>	
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		<u>SMALL &amp; MEDIUM FAB RESOURCE 1</u>	
		Deburr if necessary	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

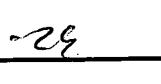
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services	Drawing Name: WEARPAD
Job Number: 44322	Part Number: D26483
Job Number:	
Seq. #: 6.0	Machine Or Operation: BRAKE NC
	Description: NC BRAKE
	
Comment: NC BRAKE	1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D2648-3
7.0	LARGE FAB 1
	Description: LARGE FABRICATION RESOURCE 1
	
Comment: LARGE FABRICATION RESOURCE 1	1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary
8.0	QC10
	Description: VISUAL INSPECTION OF GROUND WELDS
	
Comment: VISUAL INSPECTION OF GROUND WELDS	
9.0	QC5
	Description: INSPECT WORK TO CURRENT STEP
	
Comment: INSPECT WORK TO CURRENT STEP	
10.0	POWDER COATING
	Description: POWDER COATING
	
Comment: POWDER COATING	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3
	
START TIME: 13:16	
OVEN TEMPERATURE: 320°	
FINISH TIME: 14:10	
11.0	QC3
	Description: INSPECT POWDER COAT/CHEMICAL CONVERSION
	
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
12.0	PACKAGING 1
	Description: PACKAGING RESOURCE #1
	
Comment: PACKAGING RESOURCE #1	Identify and Stock Location: FP-16
	
	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/12/2008 3:30:49 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 44322

Part Number: D26483

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/02 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



JW 09.01.09 21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	44322
Description: Wearpad	Part Number:	D2648-3
Inspection Dwg: D2648	Rev: D	Page 1 of 1

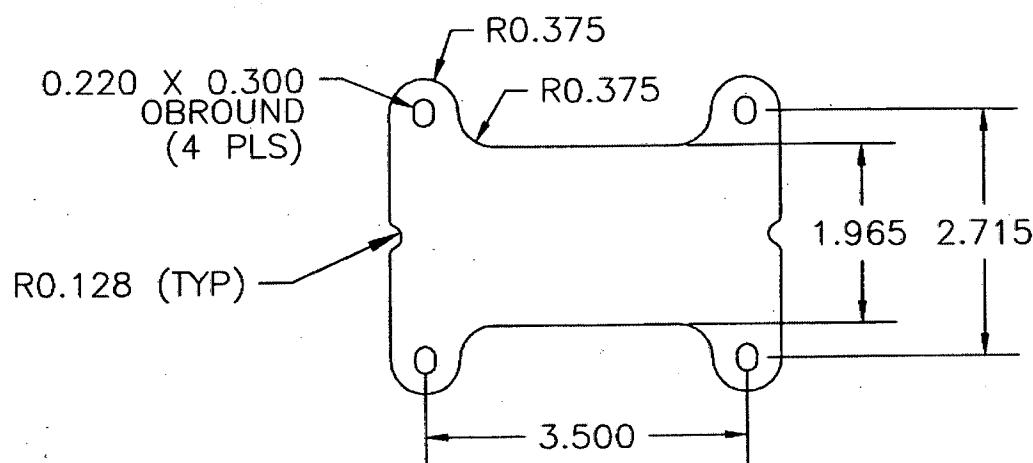
## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

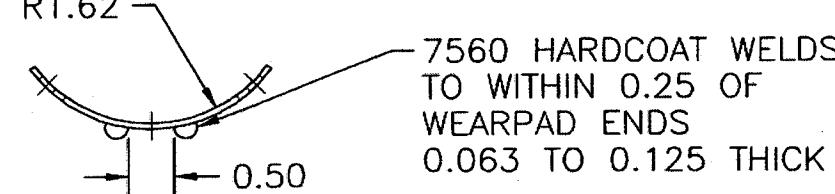
Measured by:	1B	Audited by:	S	Prototype Approval:	N/A
Date:	9-1-6	Date:	09/01/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue	KJ/JLM	<i>[Signature]</i>

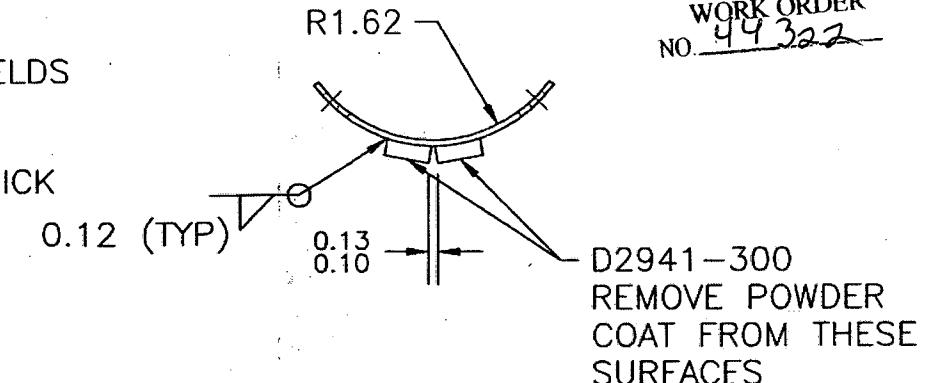
D2648-1 FLAT PATTERN



SECTION A-A

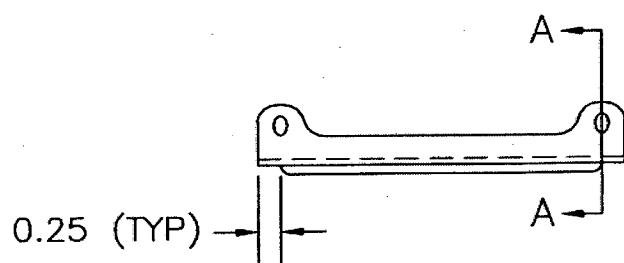


SECTION B-B

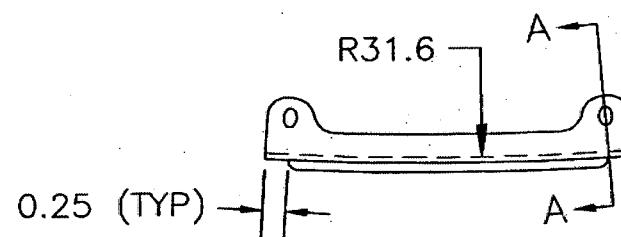


SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44322

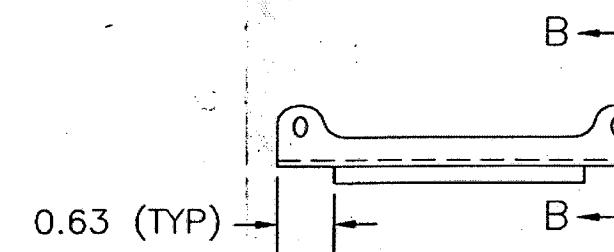
D2648-3 LONGITUDINAL BEND  
(MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND  
(MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND  
(MADE FROM D2648-1)



BREAK ALL SHARP CORNERS 0.063 MAX  
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)  
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
RF		
CHECKED	APPROVED	DRAWING NO. REV. D
RF	RF	D2648
DATE		SHEET 1 OF 1
99.11.17		SCALE
		1:2
	TITLE	WEARPAD

RELEASED  
99.12.20 DS

6 COPY ISSUED